

Date: Tuesday, 11/27/2007 7:46:09 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : JOGGLE BRACKET
Job Number : 35983	
Estimate Number : 12912	
P.O. Number : <i>N/A</i>	Part Number : D35801
This Issue : 11/27/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3580 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 35320	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/12/2007 Qty: 60 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev : A New Issue 07.06.25 EC	
Est Rev : B Removed Powder Coat 07-07-11 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S18GA	304/316 .050 Sheet
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Comment: Qty.: 0.0105 sf(s)/Unit Total : 0.6300 sf(s)

304/316 SS sheet 0.050" thick

Batch: *100997 HB 07-11-29*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3580

Dwg Rev: *B HB 07-11-29*

Prog Rev: *B*

2-Deburr if necessary

[Signature] 07/12/03

(90)

SB

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-11-29

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

counters 02/12/03 x90

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Bend as per dwg D3580 using 1/8" offset die

[Signature] 07/12/21 SB 07/12/20

(90)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/27/2007 7:46:09 AM

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Drawing Name: JOGGLE BRACKET

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 12/12/24 (90) (90)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 3T110

AS 07/12/27 (90)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/12/03

Job Completion



2008/1/2

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

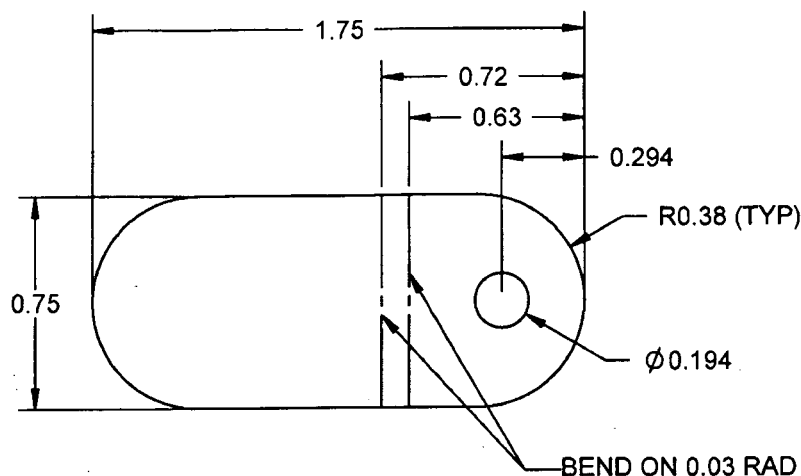
NOTE: Date & initial all entries



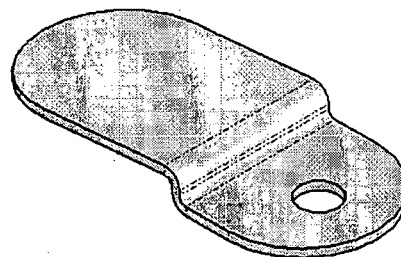
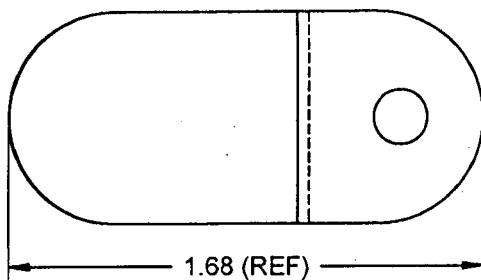
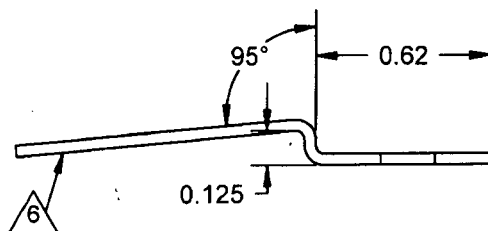
DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE JOGGLE BRACKET	SCALE 3:2
REV	DATE	DESCRIPTION	
A	07.05.15	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED

07.07.09 *[Signature]*



D3580-1F FLAT PATTERN



D3580-1 JOGGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35983

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